

Work Order ID 83314

83314

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Tuesday, April 17, 2012 1:14:17 PM

Item ID: D3601-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Radius Block
 Start Date: 4/17/2012 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 20417 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3601	Rev A								

100 0.00
100 SHEAR
 Shear Memo 0.00 *OK 12/04/19* 48 ~~✓~~
 Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 8 pieces

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00 *OK 12/04/20* 48 ~~✓~~
 HAAS CNC vertical machine #1 1- Mill as per Folio FA682 Rev: AA & Dwg D3601 Rev: A

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00 *OK 12/04/20* 48 ~~✓~~
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	12/04/20		45		BR 12-4-23	
140 *140* Small Fab Small Fab	Small Fab Memo 1-Tumble 2-Deburr any rough edges after tumbling	0.00 0.00				46		BR 12-4-23	
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				46		BR 12-4-24	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

83314

Tuesday, April 17, 2012 1:14:18 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/17/2012 **Start Qty:** 30.00

30

Cust Item ID:

Required Date: 4/25/2012 **Req'd Qty:** 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 856

0,00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 83314

83314

Parent Item: D3601-1

D3601-1

Parent Item Name: Radius Block

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No				f	75.3030		1.998			

M6061T6B00750X00 125

**

6061-T6 Bar .750 x .125

Location	Loc Qty	Loc Code
MAT001	11.168	
116406	2.75	
117653	8.418	
MAT003	64.135	
119653	41.4	
120603	22.735	

4.5

OK 12/04/19

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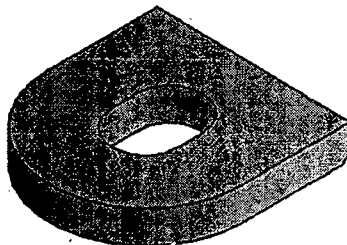
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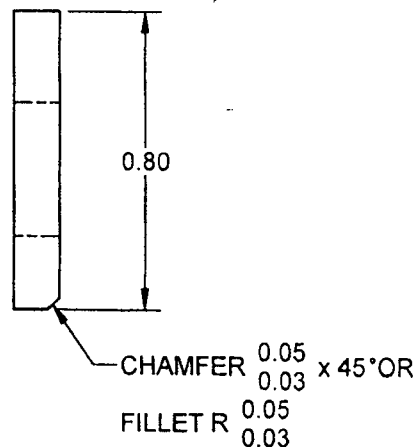
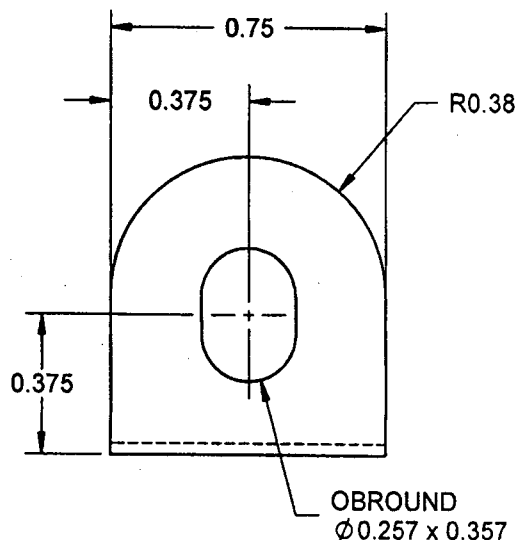
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13	TITLE RADIUS BLOCK		SCALE 2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

RELEASED
07.03.08 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *83314*

pl 12-04-117



D3601-1 RADIUS BLOCK

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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Dart Aerospace Ltd

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